

5/41

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24081
<b>Description:</b> Long Step Assembly - High Skid, LH	<b>Part Number:</b>	D350-591-311
<b>Dwg:</b> D3272 Rev. A	<b>Qty:</b>	10
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Dwg not required</b>	HJ	05-08-23	10
2	DC	Photocopy bluefile and type labels as per PPP D350-591-311 <b>CHG001</b>	UK 39 HJ	05-09-29	10
3	GA	Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A <b>Pick:</b> Qty Part Number Description Batch 1 D2622-120C Extrusion 324563	PE	06-03-27	10
4	GA	Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.	PE	06-03-28	10
5	GA	Deburr	PE	06-03-28	10
6	QC5	Inspect work to Step 5	PE	06-03-28	10
7	WA	Bevel end for welding <b>FWD ONLY</b>	PE	06-03-28	10
8	WA	Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 <b>Pick:</b> Qty Part Number Description Batch 1 D3067-1 End Plate 324205 2 D3219-1 Support 323351 324094 A/R Aluminum Rod M18838	PE	06-03-28	10
9	GA	Grind End Plate flush	PE	06-03-29	10
10	QC9 & 5	Inspect weld and work to Step 9	AA	06-03-29	10
11	FP	Chemical conversion coat as per QSI 005 4.1	TH	06-03-29	10
12	GA	Assemble Leg Assembly as per Dwg D3272. (D3066-1 is part of D3065-041 Step Leg Assembly, do not add to BOM.) <b>Pick:</b> Qty Part Number Description Batch 1 D3065-041 Step Leg Assy 324408 2 D3066-1 Spacer 324408 16 MS20600AD4W4 Rivet M18125	PE	06-04-05	10
13	QC5	Inspect work to step 12	PD	06-04-05	10
14	WA	Bevel Aft end for welding	PE	06-04-05	10
15	WA	Inspect for foreign object as per QSI 024	PE	06-04-05	10
16	WA	Weld Aft End Plate as per QSI 004 & Dwg D3272 <b>Pick:</b> Qty Part Number Description Batch 1 D3067-1 End Plate 324205 A/R Aluminum Rod M18838	PE	06-04-05	10
		Identify as D3272-041			

**RELEASED**  
04.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/04/17

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24081
<b>Description:</b> Long Step Assembly – High Skid, LH		<b>Part Number:</b>	D350-591-311
<b>Dwg:</b> D3272 Rev. A		<b>Qty:</b>	10
		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty																																																																
17	GA	Grind End Plate flush	FF	06.04.06	10																																																																
18	QC9 & 5	Inspect work to Step 17 – Check dimension 108.93" & 3.375" as per Dwg D3272	DL	06-04-06	10																																																																
19	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	DL	06/04/12	10																																																																
20	FP	Wing Walk as per Dwg D3272 and QSI 005 4.4	a.m	06/04/12	10																																																																
21	QC3	Inspect Powder Coat and Wing Walk	DL	6/4/12	10																																																																
22	KP	<p><b>Pick: Packing Kit (Note: D3272-041 is on BOM as material listed in Step 3)</b></p> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>4</td><td>D2230-3</td><td>Mounting Lug</td><td>B26203</td></tr><tr><td>2</td><td>D2618</td><td>Bushing</td><td>B24091</td></tr><tr><td>2</td><td>D2856-400-720</td><td>Abrasion Strip</td><td>B26041</td></tr><tr><td>2</td><td>D3235-1</td><td>Mounting Lug</td><td>B24095</td></tr><tr><td>1</td><td>D3272-041</td><td>Step Assembly</td><td>B24081</td></tr><tr><td>1</td><td>D3278-041</td><td>Support Assembly</td><td>B24096</td></tr><tr><td>2</td><td>AN3-35A</td><td>Bolt</td><td>A119551</td></tr><tr><td>8</td><td>AN4-13A</td><td>Bolt</td><td>A119099</td></tr><tr><td>2</td><td>AN5-36A</td><td>Bolt</td><td>A116144</td></tr><tr><td>4</td><td>AN960JD10</td><td>Washer</td><td>A119521</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>A1100515</td></tr><tr><td>4</td><td>AN960JD516</td><td>Washer</td><td>A118254</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>A118917</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>A119079</td></tr><tr><td>2</td><td>MS21042L5</td><td>Nut (or -5)</td><td>A119073</td></tr></table>	Qty	Part Number	Description	Batch	4	D2230-3	Mounting Lug	B26203	2	D2618	Bushing	B24091	2	D2856-400-720	Abrasion Strip	B26041	2	D3235-1	Mounting Lug	B24095	1	D3272-041	Step Assembly	B24081	1	D3278-041	Support Assembly	B24096	2	AN3-35A	Bolt	A119551	8	AN4-13A	Bolt	A119099	2	AN5-36A	Bolt	A116144	4	AN960JD10	Washer	A119521	16	AN960JD416	Washer	A1100515	4	AN960JD516	Washer	A118254	2	MS21042L3	Nut (or -3)	A118917	8	MS21042L4	Nut (or -4)	A119079	2	MS21042L5	Nut (or -5)	A119073			
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23	QC4	Inspect Kit 100% for Completeness on the W/O	R	06/04/10	10																																																																
24	PK	Package for shipping as per PPP D350-591-311 Rev. B	R	6/4/10	10																																																																
25	AC	Cost / part	R	06/04/10	10																																																																
26	DC	Close W/O Inspect Level 21	U	06/04/17	10																																																																

Rev	Date	Change	Revised By	Approved
A	04.03.22	New issue	KJ/RF	

**RELEASED**  
04.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 18, 2005  
10:59 am

Work Order No : 0024081  
Project Name : D350-591-311  
Project For : WK541  
Work Order Type : Main  
Main WO Number :  
House Part Number : \*D350-591-311  
Description : Heli-Access-Step, LH Hi  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 08-16-05  
Est Finish Date : 10-10-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00